

TUBES!!

Dart Aerospace Ltd.

Date: Thursday 7/19/2007 2:25:35 PM
 User: Kim J. Mon

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: TOW CAP
Job Number	33658		
Estimate Number	10483		
P.O. Number	N/A	Part Number	: D3401041
This Issue	: 7/19/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3401 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31346	Drawing Revision	: B
		Material	: N/A
		Due Date	: 8/3/2007
Written By	: <u>[Signature]</u>	Qty:	12 Um: Each
Checked & Approved by	: <u>[Signature]</u> 07.07.19		
Comment	: Est. A 05/09/01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R3500	Inventory
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Comment: Qty.: 0.3675 f(s)/Unit Total : 4.4100 f(s)

Inventory

Material: 6061-T6 Round Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6R3.500)

Batch: 100720

[Signature] 07-12-05

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Blanks

[Signature] 07-12-05

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA532 & Dwg D3401

Folio Rev: ADwg Rev: B

Deburr

[Signature] 07-12-05

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 07-12-05

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Haas #1

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: BFolio Rev: AA

Deburr & Buff rad as per Dwg D3401

Identify as D3401-1

[Signature] 07/12/27

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:25:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW CAP

Job Number: 33658

Part Number: D3401041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 07/12/27

(6)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and c'sink using DT8782 as per Dwg D3401

ml 08/01/03

(x6)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 08/01/03 (x6)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/01/03 (6)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 08/01/03 (6)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08-01-03 (6)

12.0

NAS1330C3KB116

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Insert

Pick:

Qty Part number Description Batch

4 NAS1330C3KB116 Insert

M100712

Assemble as per Dwg D3401

Identify as D3401-041

FL 08-01-03 (x6)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 08/01/04 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 08/01/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:25:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW CAP

Job Number: 33658

Part Number: D3401041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F92D

U

08-01-04

26

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/01/04

Job Completion



in 2008/1/4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

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111	APPROVED
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D3401

SHEET 1 OF 1

3711

SCALE

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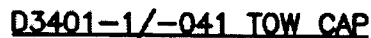
03.02.

NEW 13-

05.06

CHAMPE

5



- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-200/8
(REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI .018 UNLESS OTHERWISE NOTED

1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33658

05-08-69

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DART AEROSPACE USA, INC.
PORT HADLOCK, WA

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DRAWING NO.

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DATE

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05.06.09

LOW CARB

7:2

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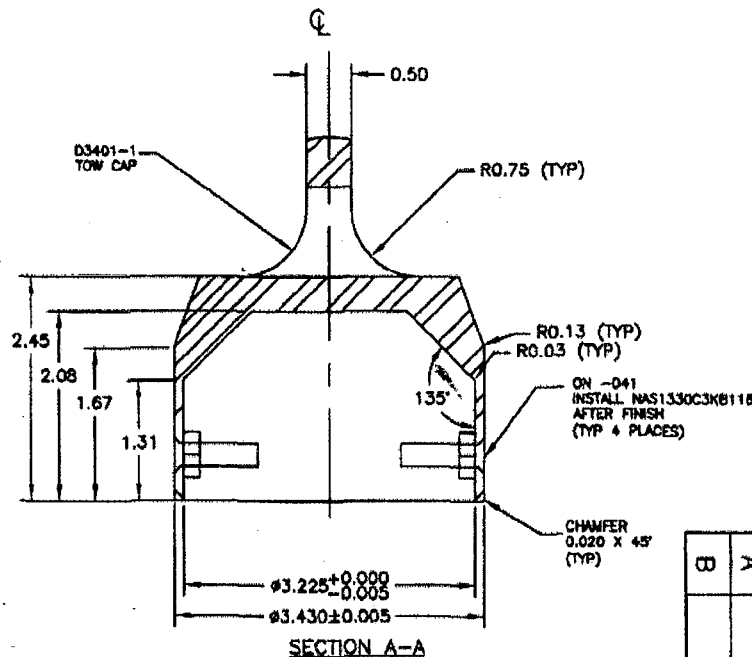
4770:00

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Q

00:00:00

CHAMFEN INSIDE, REMOVE RADIO



D3401-1 TOW CAP

D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-200/8
(REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

05-08-57

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